

Date: Tuesday, 13/05/2008 9:28:22 AM  
 User: Julie Lecocq

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: PLATE		
Job Number	: 39229					
Estimate Number	: 12668					
P.O. Number	:			Part Number	: D323835	
This Issue	: 13/05/2008		S.O. No.	: D3238 REV C		
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 30746			Drawing Revision	: C	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 08-5-13</u>			Due Date	: 30/05/2008	
Comment	: Est Rev:A New Issue 07-01-26 JLM			Qty:	10	Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S020	6061-T6 .020 Sheet	
		Comment: Qty.: 0.0252 sf(s)/Unit Total.: 0.2520 sf(s) 6061-T6 .020 Sheet Batch: <u>3019</u> <u>HB 8-5-21</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3238 Dwg Rev: <u>C</u> <u>HB 8-5-21</u> Prog Rev: <u>C</u>	(10)
		2-Deburr if necessary ***Use cutting file D3238-21-23-25*****	→ 08/05/21 (10) Hm
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>HB 8-5-21</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>08/05/21 (10)</u>	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		<u>HB 08-05-21</u>	(10)
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 9:28:22 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 39229

Part Number: D323835

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		<i>(Xox)</i>
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<i>8/5/21</i>
7.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>(Xox)</i>
	Comment: PACKAGING RESOURCE #1	
	Identify and Stock	
	Location: <i>78</i>	<i>8/5/21</i> <i>SP</i>
8.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>08/05/2022</i> <i>MF</i>
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion



*MF 08-05-22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

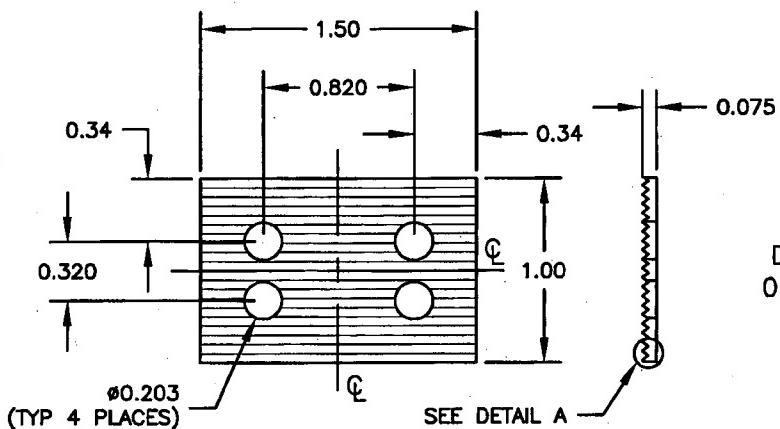
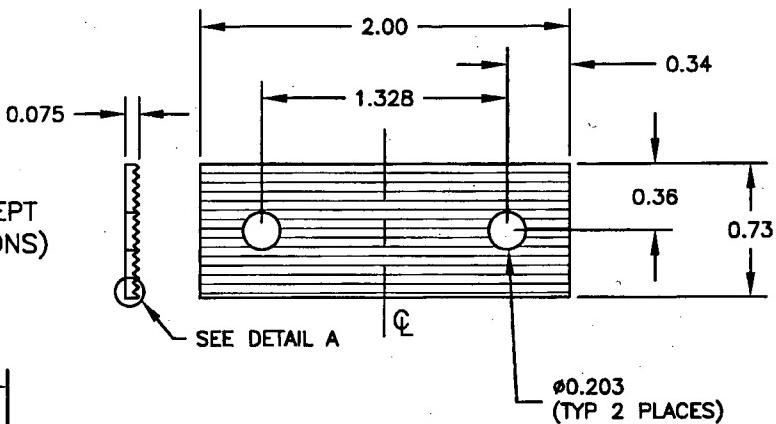
**DART**

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3238 REV. C SHEET 1 OF 3
DATE 07.02.19		TITLE PLATE SCALE 1:1
A	03.11.25	NEW ISSUE
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6
C	07.02.19	ADD 5052-H32 OPTION

RELEASED

07.02.20 *CH*

**D3238-1 PLATE (SHOWN)**  
D3238-11 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-3 PLATE (SHOWN)**  
D3238-13 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

**NOTES:**

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:  
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S)  
-11/-13/-15/-31/-33/-35 PLATE:  
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)  
OR  
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR  
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT  $\frac{1}{4}$

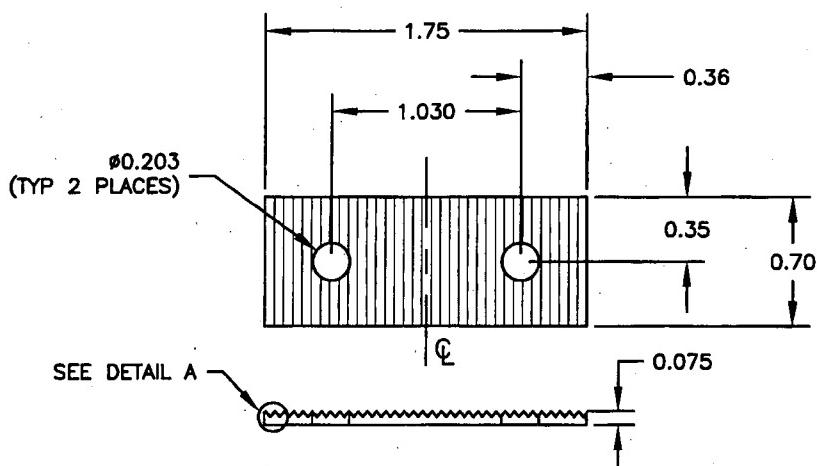
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WORK ORDER  
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**DART**

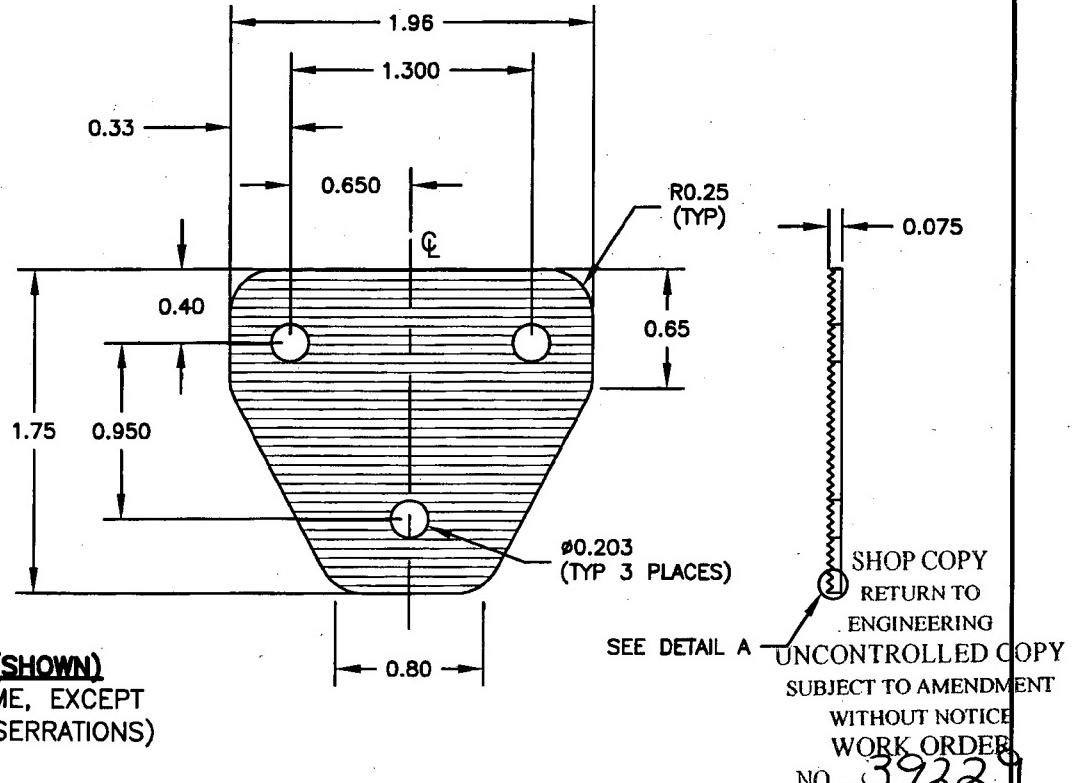
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CHECKED <i>CE</i>	APPROVED <i>HH</i>	DRAWING NO. D3238
DATE 07.02.19		TITLE PLATE

REV. C  
SHEET 2 OF 3  
SCALE  
1:1

RELEASED

07.02.20 *CH*

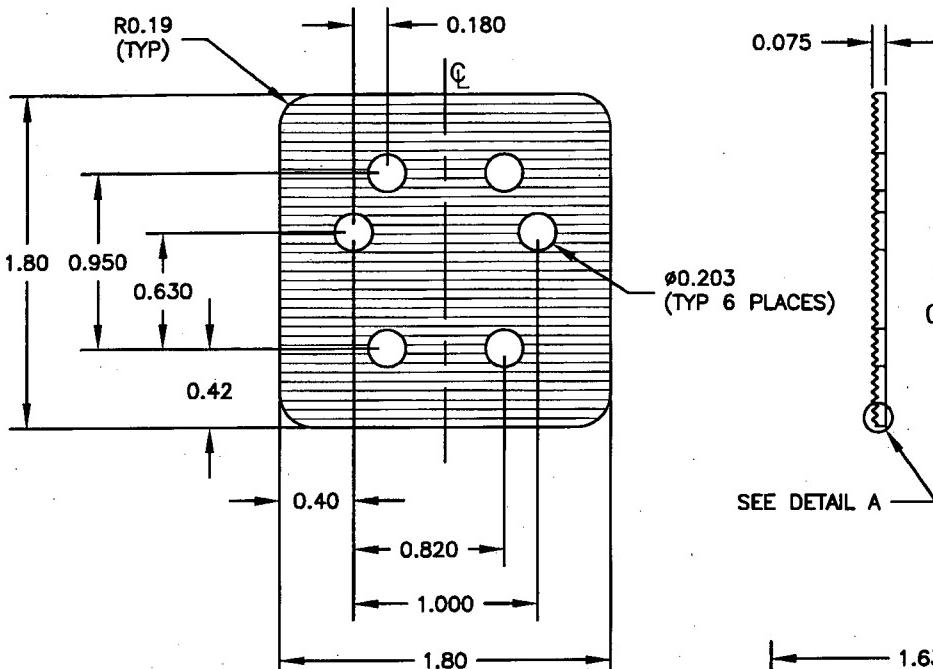
**D3238-5 PLATE (SHOWN)**  
D3238-15 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-21 PLATE (SHOWN)**  
D3238-31 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1

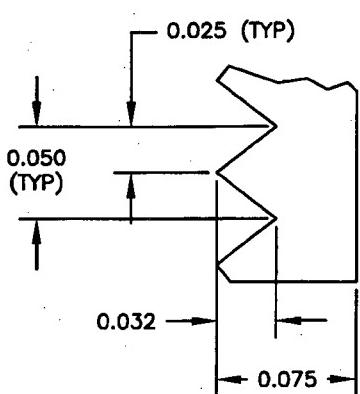


RELEASED

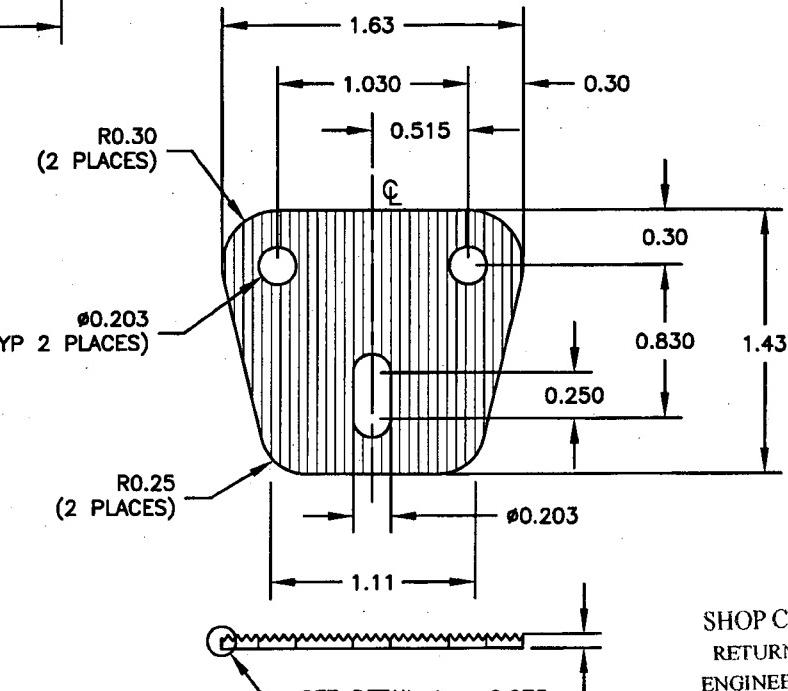
07.02.20 *CH*

**D3238-23 PLATE (SHOWN)**  
D3238-33 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

SEE DETAIL A



**DETAIL A**  
RIDGE DETAIL (VIEW MAY BE ROTATED)  
SCALE 10:1



SEE DETAIL A

**D3238-25 PLATE (SHOWN)**  
D3238-35 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

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**SCOTT AEROSPACE LTD**

Work Order: 39229

Description: PIATE

Part Number: D3238-35

Inspection Dwg: 02238-35 Rev: C

Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article Prototype

Measured by:

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Audited by

#### **Prototype Approval**

265

8-5-21

Date:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

